

Work Order ID 147332

Wednesday, June 08, 2016 2:54:09 PM

147332

Page 1

Item ID: D3414-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 5/31/2016 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUN 10 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3414	Rev C

100		0.00							
100									
Bandsaw	Memo	0.20							
Jeaspa Bandsaw	Cut blanks: 2.50" x 0.500" x 2.250" long								
	56								
110		0.05							
110									
HAAS 1	Memo	0.60							
HAAS CNC vertical machine #1	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3Dwg Rev <u>C</u> Folio Rev <u>AB</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.10							
Quality Control									

30 0 LR 16-07-25

30 0 DAS 20 9-8F 16-07-28

30 0 DAS 20 9-8F 16-07-28

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Work Order ID 147332

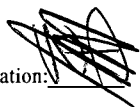
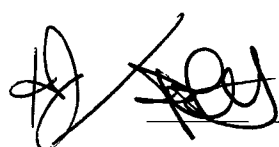
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147332

Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.10							DAS 08 9-89
Quality Control									
140	Identify as per dwg & Stock Location: 	0.00							
140									
Packaging	Memo	0.50							DAS 6 9-89
Packaging	LOCATION: WA001								30 JUL 29 2016
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.05							 6/08/03
Quality Control									

DAS
21
9-89

AUG 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 147332

147332

Parent Item: D3414-3

D3414-3

Parent Item Name: Lug

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased			No	100	f	7.5183	0.1875	5.625			

M304B0 500X2 500

**

304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT009

7.5183

m134551

7.5183

5.94 16-07-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Description Work Order Deviation				Disposition				Completed By	
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OTHER : _____									

DART AEROSPACE LTD		Work Order:	147332
Description: Lug		Part Number:	D3414-3
Inspection Dwg: D3414 Rev: C		Page 1 of 1	

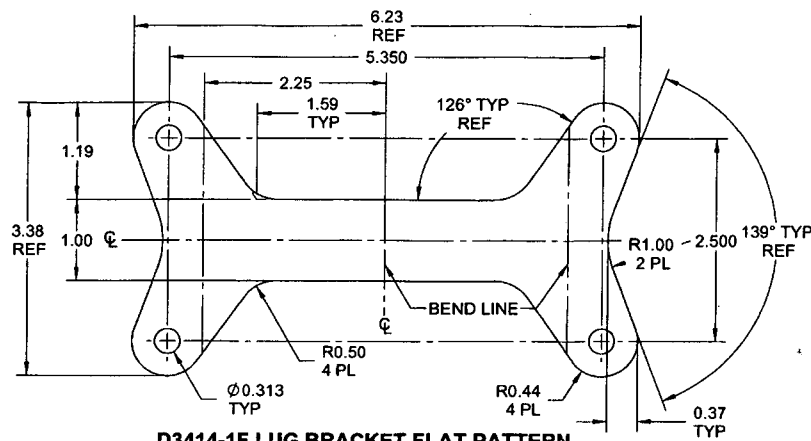
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

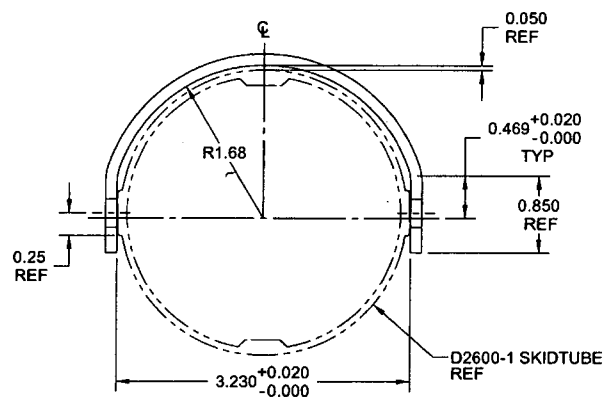
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	.512	✓		SLIO	Veru
2.07	+/-0.030	2.070	✓			
1.99	+/-0.030	1.990	✓			
1.30	+/-0.030	1.299	✓			
1.12	+/-0.030	1.120	✓			
0.38	+/-0.030	.373	✓			
0.060	+/-0.010	.062	✓			

Measured by: DAS 20 9-89		Audited by: DAS 08 9-89		Prototype Approval: N/A	
Date: 16-07-27		Date: 16/07/28		Date: N/A	

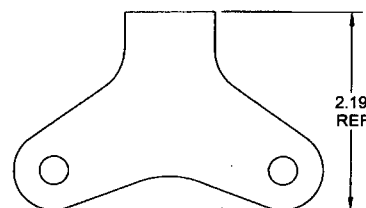
Rev	Date	Change	Revised by	Approved
A	09.09.14	New Issue	KJ	
B	09.11.12	Dwg Rev updated	KJ	



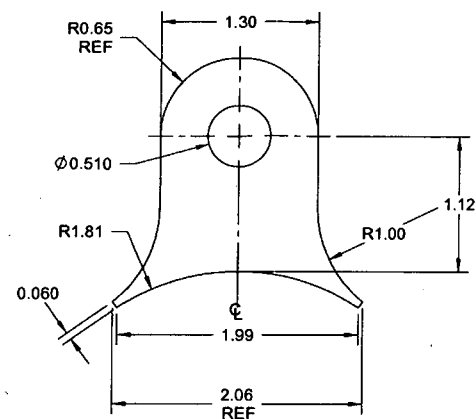
D3414-1F LUG BRACKET FLAT PATTERN



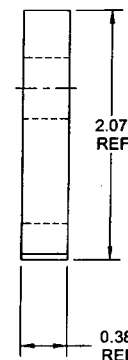
D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO AMENDMENT
NOTICE
ORDER

147332ML5

160610

RELEASED

- NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OP		
CHECKED	h	DRAWING NO. D3414	REV. C
MFG. APPR.	h	SHEET 3 OF 3	
APPROVED	h	TITLE LUG ASSEMBLY	SCALE NTS
DE APPR.	h	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	09.06.17		